

Date: Monday, 10/30/2006 4:15:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 29236B		
Estimate Number	: 10462	Part Number	: D32782
P.O. Number	: <i>N/A</i>	Drawing Number	: D3278 REV. B
This Issue	: 10/30/2006 S.O. No. : <i>N/A</i>	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: B
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Material	: <i>N/A</i>
Previous Run	: 28273B	Due Date	: 11/20/2006 Qty: 40 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i> 061031		
Comment	: Est:A 04.04.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.4572 f(s)/Unit Total : 18.2868 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: *M101421*
ml 06/11/02 40

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

ml 06/11/02 40

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

ml 06/11/03 40

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/11/03 40

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/11/10 (38)

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/10	3	2 pieces are too thin. Dimension .119" +.005 - .004 Actual dimension is .112"	AB 05/11/12	destroy pieces pieces	J.F. 06/11/10	AD 06/11/10	CP 06.11.17 CS/642	2 06.11.20

NOTE: Date & initial all entries

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Drawing Name: SUPPORT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YLR 06/11/15 x 38

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YLR 06/11/16 x 38

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FF 06-11-16

38

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

FF 06-11-16

38

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/17

(38)

Job Completion



W 06-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29236 B
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø0.099	—			
0.359	+/-0.005	0.359	—			
0.615 0.609	+/-0.010	0.615	—			
0.250	+/-0.010	0.251	—			
1.480	+/-0.005	1.479	—			
R0.125	+/-0.010	R0.125	—			
0.119	+0.005/-0.004	0.122	—			
2.439	+/-0.010	2.439	—			
1.980	+/-0.010	1.981	—			
R0.130	+/-0.010	R0.130	—			
Ø0.257	+0.005/-0.000	Ø0.260	—			
R0.375	+/-0.010	R0.375	—			
0.875	+/-0.010	0.875	—			
0.500	+/-0.010	0.500	—			
R0.400	+/-0.010	R0.400	—			
1.720	+/-0.010	1.721	—			
R0.125	+/-0.010	R0.120	—			
0.125	+/-0.010	0.126	—			

Measured by:	mf	Audited by:	J.L	Prototype Approval:	N/A
Date:	06/11/03	Date:	06/11/03	Date:	N/A

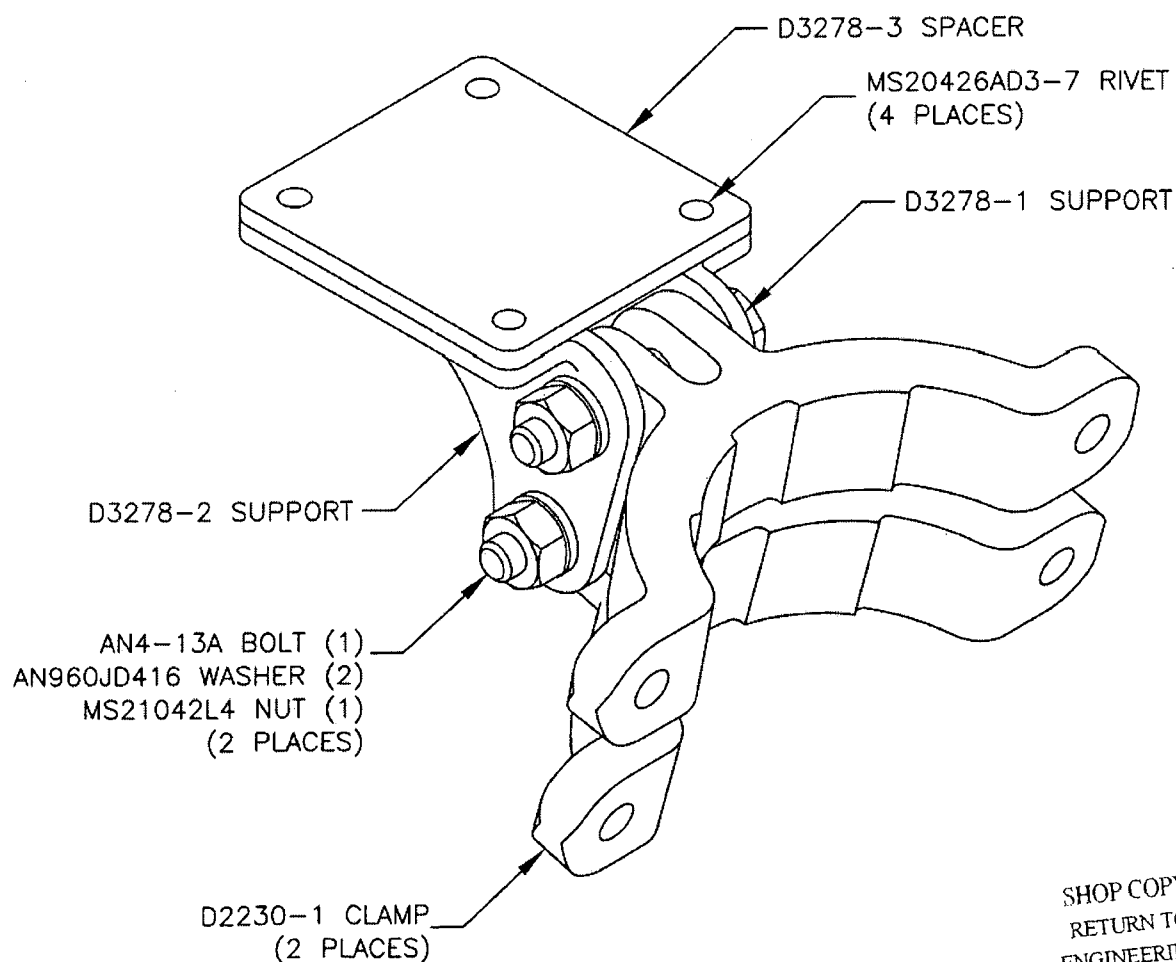
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE	05.03.31		TITLE	SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03		NEW ISSUE		
B	05.03.31		CHANGE DIM/TOL TO ENSURE FIT		

RELEASED
05.04.04



D3278-041 SUPPORT ASSEMBLY



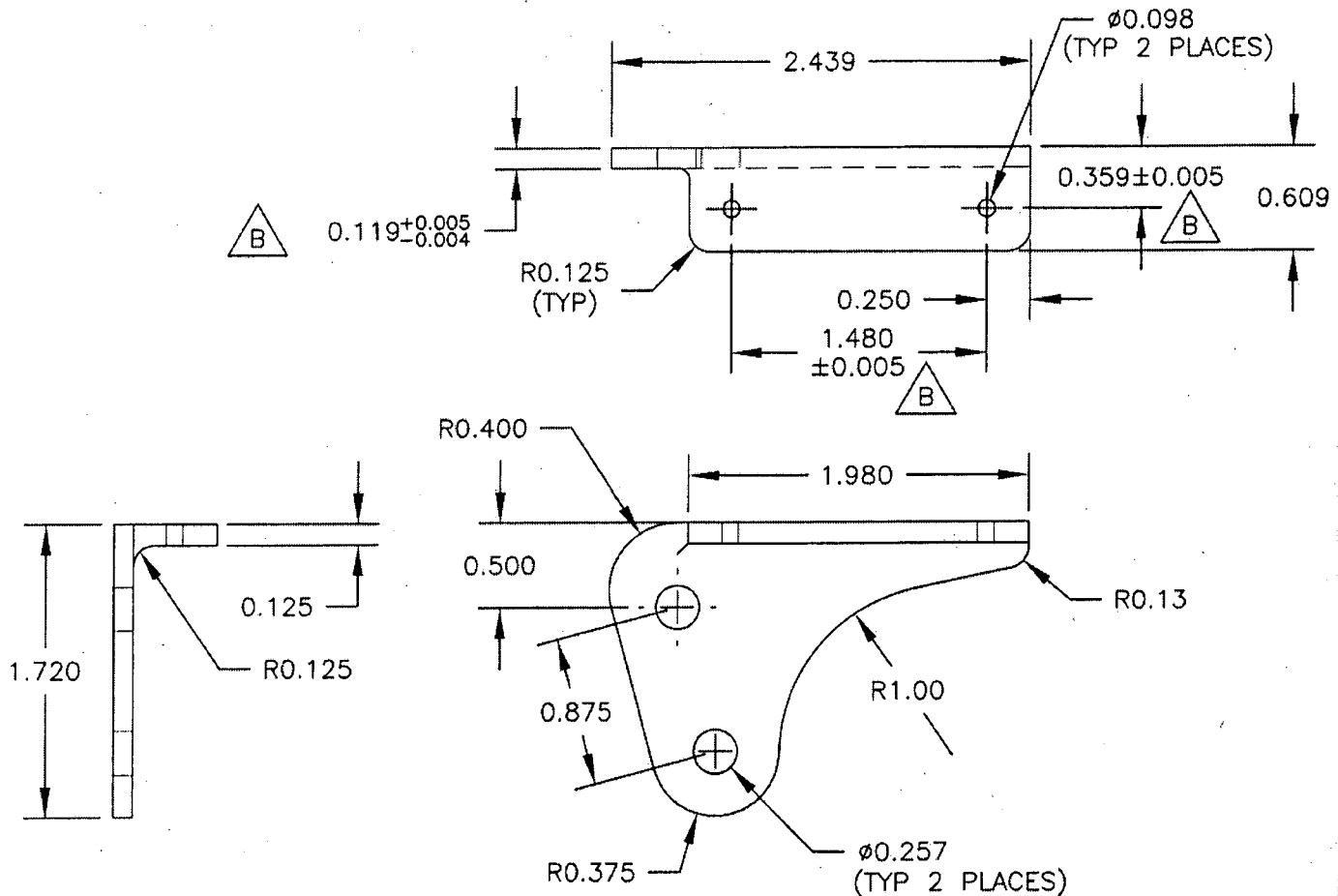
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

05.04.04



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR C
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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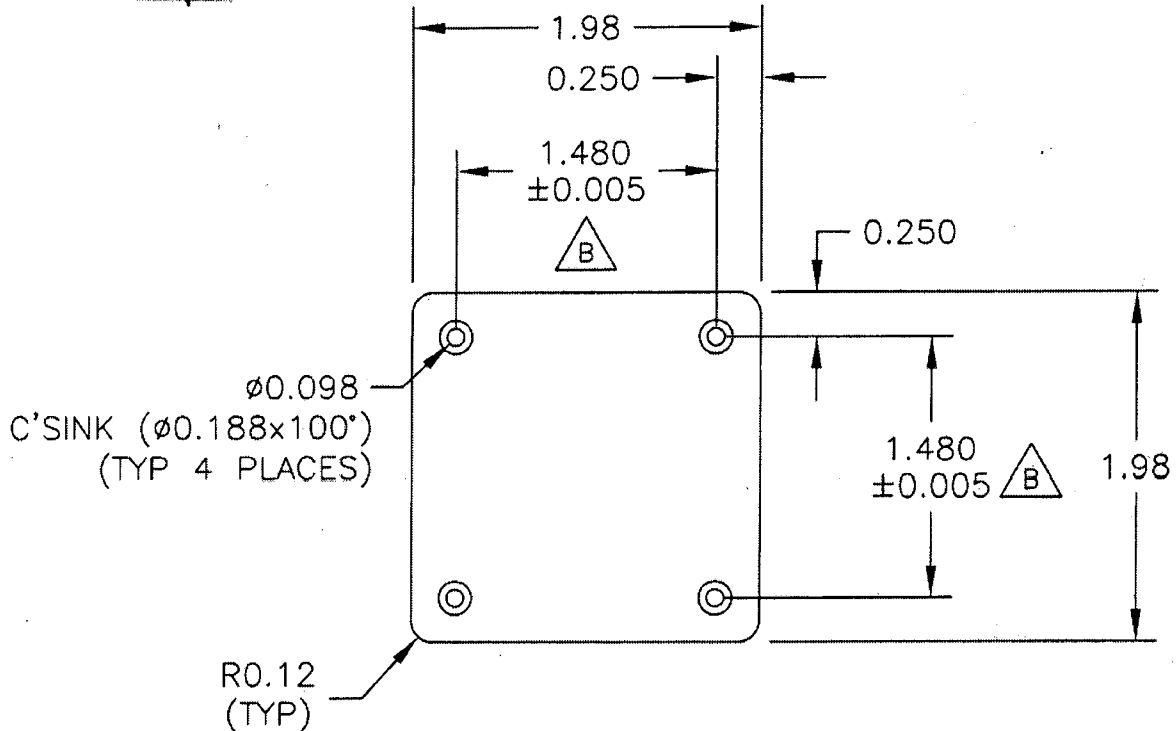
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]***D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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